

Work Order ID 58317

May 3, 2010 11:43:04 AM



Page 1

Item ID: D4030-043

Accept



Setup Start



Revision ID:

Item Name: Long Basket Assembly, Light Lid (350)

Stop



Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 10-5-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	B

100 Pick Kit 0.00



Packaging Memo 0.00

Packaging

Pickup 1

110 Assemble as per dwg 0.00



HandFinish Memo 0.00

Hand Finishing

10/05/07 1

120 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

8 10/05/07

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4030-043

Accept



Setup Start



Revision ID:

Item Name: Long Basket Assembly, Light Lid (350)

Stop



Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPD

58302

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MK

10-5-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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May 3, 2010 11:43:11 AM

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 03/05/2010

Required Date: 13/05/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

[illegible]

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Picklist Print

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Work Order ID: 58317



Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 03/05/2010



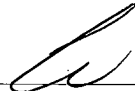









Required Date: 13/05/2010

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3917-3  Washer		Manufactured	No			100	Each	1.0000	6	 58186		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST096		1						
				57144		1						
D3953-3  Gas Spring Stud, Lid		Manufactured	No			100	Each	7.0000	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST101		7						
				53757		1						
				57978		6						
D3953-7  Spring Spacer		Manufactured	No			100	Each	15.0000	2	 53757 1p 57978 1p		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST101		15						
				53970		15						
D3953-9  Gas Spring Washer		Manufactured	No			100	Each	30.0000	2	 53970		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST101		30						
				53642		30						
				</								

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D3953-17  Gas Spring Spacer		Manufactured	No			100	Each	8.0000	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				8				
					57143			8				
D3953-19  Gas Spring Bracket		Manufactured	No			100	Each	14.0000	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				14				
					57607			14				
D3953-21  Gas Spring Bracket		Manufactured	No			100	Each	22.0000	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ENG				6				
					56407			6				
				ST102				16				
					57145			16				
D3969-3  Spring (Basket Lid)		Manufactured	No			100	Each	3.0000	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ENG				3				
					55716			3				

57143

57607

57145

55716

10/5/10

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Page 3

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-14A  Bolt		Purchased	No			100	Each	98.0000	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST351				98				
					114330			98				
AN3-20A  Bolt		Purchased	No			100	Each	45.0000	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST352				45				
					105125			45				
AN4-12  Bolt		Purchased	No			100	Each	53.0000	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST357				53				
					104016			3				
					114292			50				
AN5-17A  Bolt		Purchased	No			100	Each	169.0000	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST323				64				
					114324			64				
				ST339				105				
					113538			5				
					114330			100				

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Work Order ID: 58317

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 03/05/2010









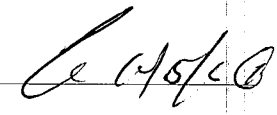
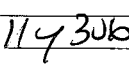
Required Date: 13/05/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN5-21A  Bolt		Purchased	No			100	Each	16.0000	2			
				<u>Location</u>				<u>Loc Qty</u>				
				ST339				16				
				16463				16				
AN310-4  NUT		Purchased	No			100	Each	64.0000	3			
				<u>Location</u>				<u>Loc Qty</u>				
				ST139				30				
				114341				30				
				ST314				14				
				113845				14				
				ST349				20				
				114341				20				
AN310C4  Nut		Purchased	No			100	Each	82.0000	2			
				<u>Location</u>				<u>Loc Qty</u>				
				ST349				82				
				114306				82				
												

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May 3, 2010 11:43:11 AM

Page 6

Work Order ID: 58317

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Start Date: 03/05/2010


Required Date: 13/05/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No			100	Each	1,762.000	6			

Location

Loc Qty

Loc Code

ST300

1762

113537

20

113644

742

114523

1000

113644

MS21042L5

Purchased

No

100

Each

697.0000

4



Nut

Location

Loc Qty

Loc Code

ST300

697

113523

26

113537

3

114108

168

114437

100

114449

400

1114408

MS24665-151

Purchased

No

100

Each

701.0000

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

701

17566

701

17566

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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May 3, 2010 11:43:11 AM

Page 7

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Start Date: 03/05/2010


Required Date: 13/05/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC


IPP Rev:B as

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS24665-300  Cotter Pin		Purchased	No			100	Each	92.0000	2			

Location	Loc Qty	Loc Code
ST309	92	
105279	2	
110123	90	

NAS1149F0432P  Washer		Purchased	No			100	Each	93.0000	6			
--	--	-----------	----	--	--	-----	------	---------	---	--	--	--

Location	Loc Qty	Loc Code
ST275	93	
112940	92	
114405	1	

NAS1149F0563P  Washer		Purchased	No			100	Each	72.0000	4			
---	--	-----------	----	--	--	-----	------	---------	---	--	--	--

Location	Loc Qty	Loc Code
ST275	72	
10847i	72	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

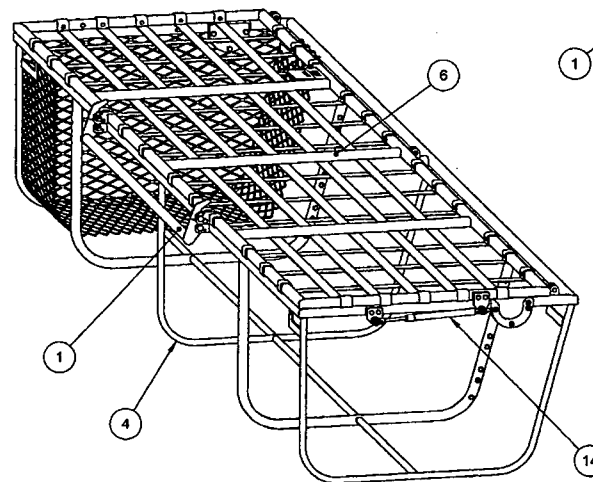
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

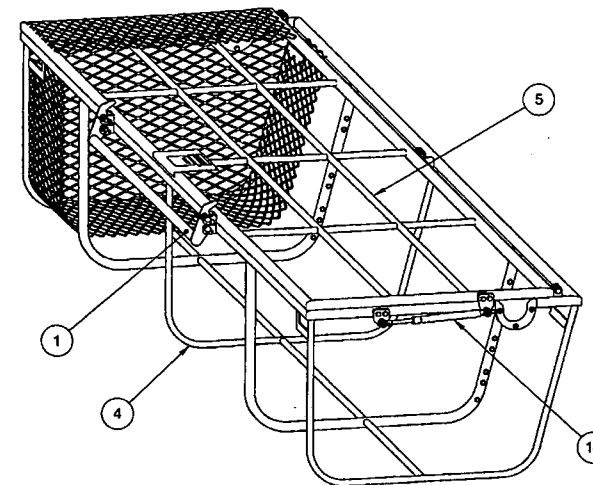
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
2010-04-14

58317

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED	JP	D4030	SHEET 1 OF 3
MFG. APPR.	JP	TITLE	SCALE
APPROVED	JP	LONG BASKET ASSY (350)	NTS
DE APPR.	JP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		

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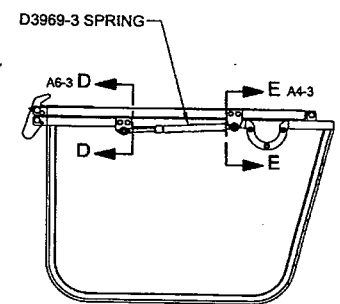
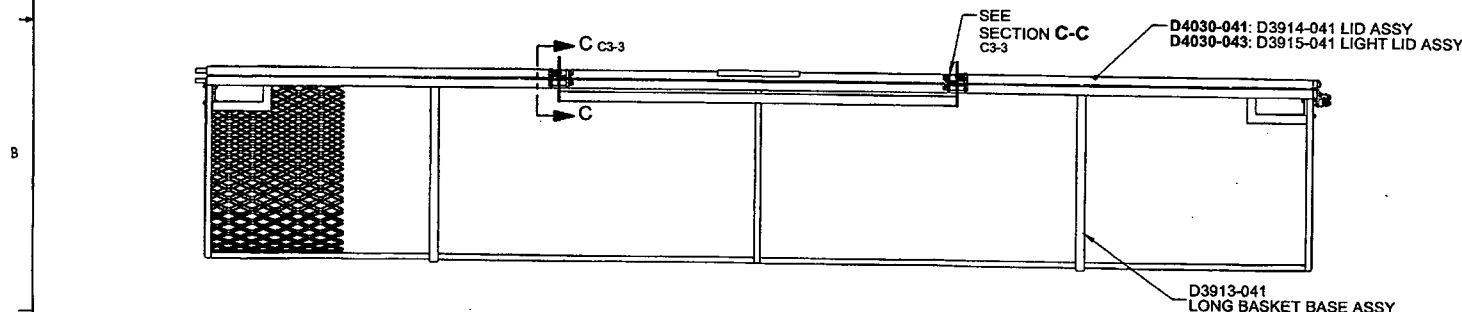
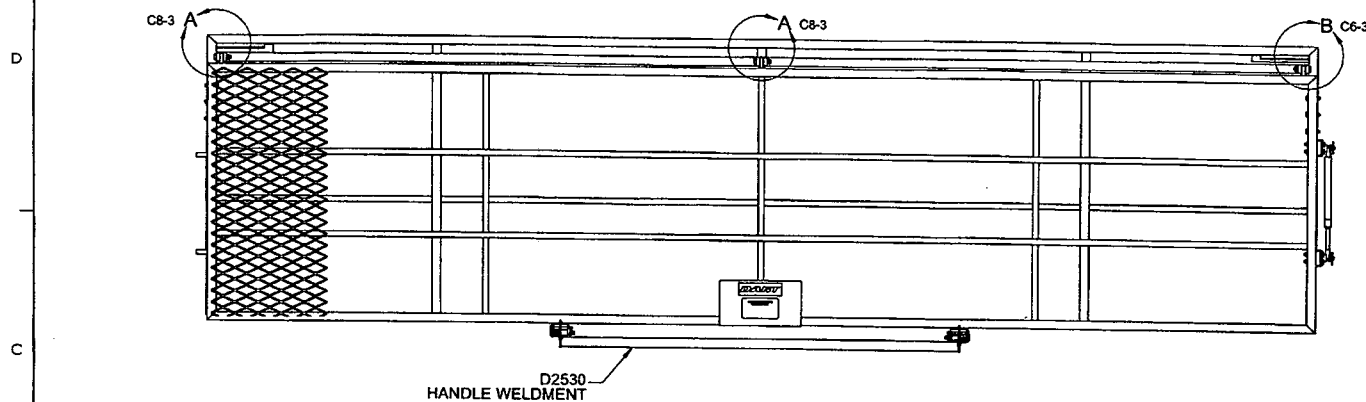
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-04-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.04.06	DRAWING NO. D4030	REV. B SHEET 2 OF 3
		TITLE LONG BASKET ASSY (350)	SCALE NTS
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8 7 6 5 4 3 2 1

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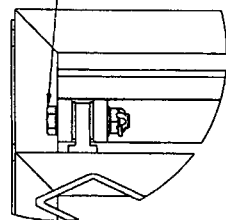
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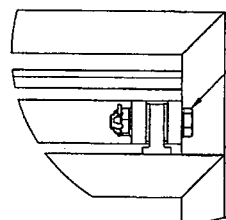
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



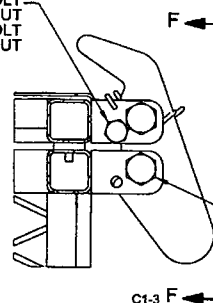
DETAIL A D8-2
D5-2



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



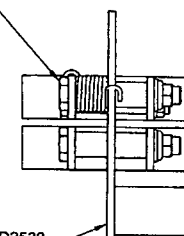
SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
D2537 BUSHING
NAS1149F0563P WASHER
MS21042L5 NUT

D2530
HANDLE WELDMENT
REF



VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
2010-04-14
JMP

58317

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED	g	D4030	SHEET 3 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED	JMP	LONG BASKET ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries